

Date: Wednesday, 25/06/2008 12:00:05 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STEP SPACER		
Job Number	: 40087C			Part Number	: D2279		
Estimate Number	: 10356			Drawing Number	: D2279 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	: 25/06/2008 S.O. No. :			Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : SMALL /MED FAB			Due Date	: 07/07/2008 Qty: 12 Um: Each		
Previous Run	: 37925C						
Written By	:						
Checked & Approved By	: JUL 08.6.25						
Comment	: Est Rev: A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		<p>Comment: Qty.: 0.1544 sf(s)/Unit Total : 1.8522 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2279 Batch: 101572 HR 8-7-3</p>
2.0	WATER JET	FLOW WATER JET
		<p>Comment: FLOW WATER JET 1-Cut as per Dwg D 2279 Dwg Rev: D HR 8-7-3 Prog Rev: D 18</p>
		<p>2-Deburr if necessary HR 8-7-3</p>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<p>HR 8-7-3</p>
		<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>
4.0	QC8	SECOND CHECK
		<p>S 08/07/08 X18</p>
		<p>Comment: SECOND CHECK</p>
5.0	BRAKE NC	NC BRAKE
		<p>Comment: NC BRAKE Form As per Dwg D2279 E08/10/08 18 SB 08/10/29</p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



S 081029 (18)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ML

08-10-30 (18)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/10/30 (18)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

544/12

08/10/30 18

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/10/30 (18)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 081030

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

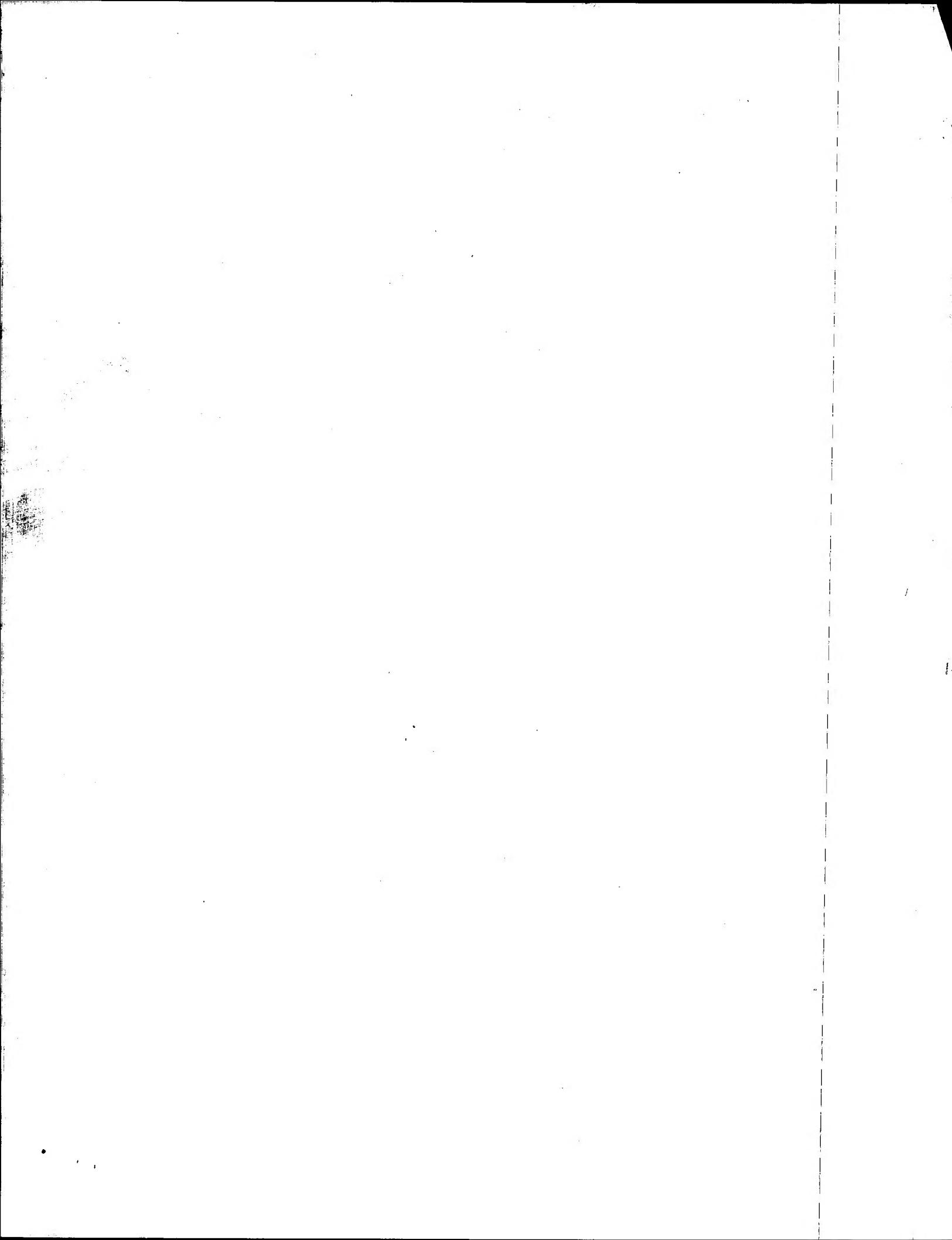
DART AEROSPACE LTD	Work Order:	40087C
Description: Step Spacer	Part Number:	D2279
Inspection Dwg: D2279	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>JB</u>	Audited by: <u>S</u>	Prototype Approval: N/A
Date: 8-7-3	Date: 08/07/03	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue	P/O D2582	KJ/JLM <i>[Signature]</i> <i>[Signature]</i>



DART

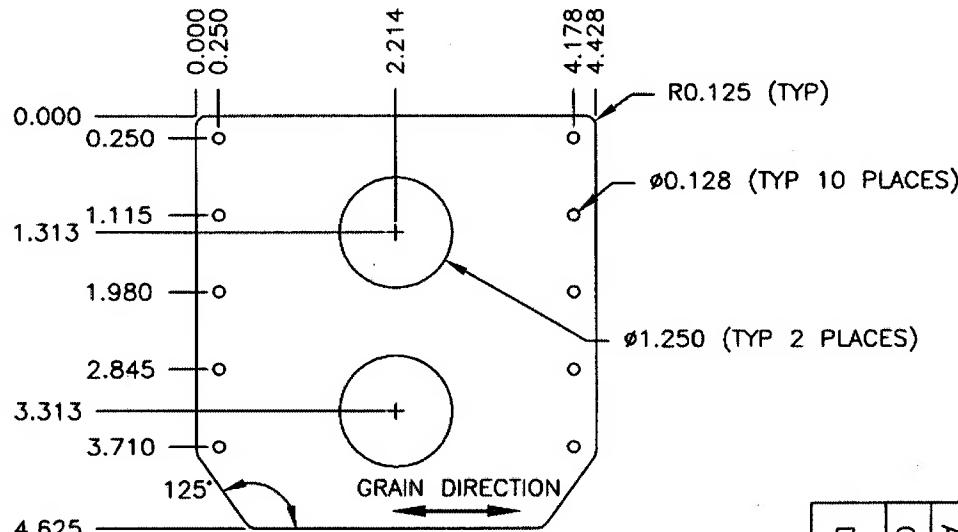
ON COPY
DRAFTED

DESIGN B/W	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RE</i>	APPROVED <i>MM</i>	DRAWING NO. D2279	REV. D SHEET 1 OF 1
DATE 98.10.05	TIME STEP SPACER		SCALE 1:2
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	

RELEASED
98.10.08 DS

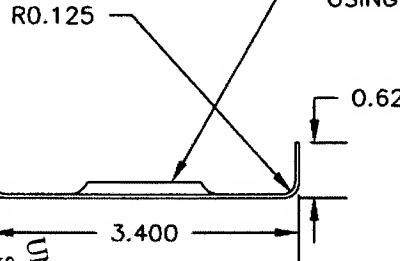
UNDER REVIEW

*10/03/94 CP
Design Review But CHECK WITH
DRAFTS BEFORE MANUFACTURE
OK 10/03/94*



FLAT LAYOUT

FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
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WITHOUT NOTICE
WORK ORDER
NO. *100810*